

Date: Thursday, 2/23/2006 10:22:51 AM
 User: Kim Johnston

Process Sheet

13

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Job Number : 25908
 Estimate Number : 12027
 P.O. Number : N/A Part Number : D412630024
 This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D412-630 REV. J, P13
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : J
 Previous Run : 25822 Material : N/A
 Due Date : 3/30/2006 Qty: 3 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : JF 06.02.23
 Comment : Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J
 LM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-024 CHG002

KJ 06.03.07

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Clevis

Pick:

Qty Part Number Description Batch

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	B25483

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number Description Batch

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	B25918

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number Description Batch

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	B25920-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

B25217

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

B25842

7.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

B23634 (5) B26141 (7)

8.0

D3388042

Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Step Weldment RH

B25927

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

M19633

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
-----	-------------	-------------

Batch

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Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN310C8 Nut

M18515

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M18779

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M100218

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984 (5)
m16941 (1)

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

W/O:		WORK ORDER CHANGES					
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Job Number: 25908

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M18535

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M18779

SAD

08/05/10

(3)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

SAD

08/05/10

(3)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

B24621

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	B25869 ✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	B28631 ✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	B24645 ✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M19512 ✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M18545 ✓

W/O:		WORK ORDER CHANGES					
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Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4C15A

Description

Bolt

Batch

M18515 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

1 AN44-C7A

Description

Eyebolt

Batch

M18535 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN5C15A

Description

Bolt

Batch

M18167 ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

4 MS21043-4

Description

Nut

Batch

M100651 ✓

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

3 MS21043-5

Description

Nut

Batch

M17997 x 4 ✓ M18535 x 5 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 26/05/11
 QA: N/C Closed: _____ Date: _____

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Job Number: 25908

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H4	Washer

Batch

118535 ✓

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

118535 ✓

06/05/10 (3)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/05/10 (3)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location: A

PPP Rev: A

06/05/11 (3)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/11 (3)
06-05-11

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

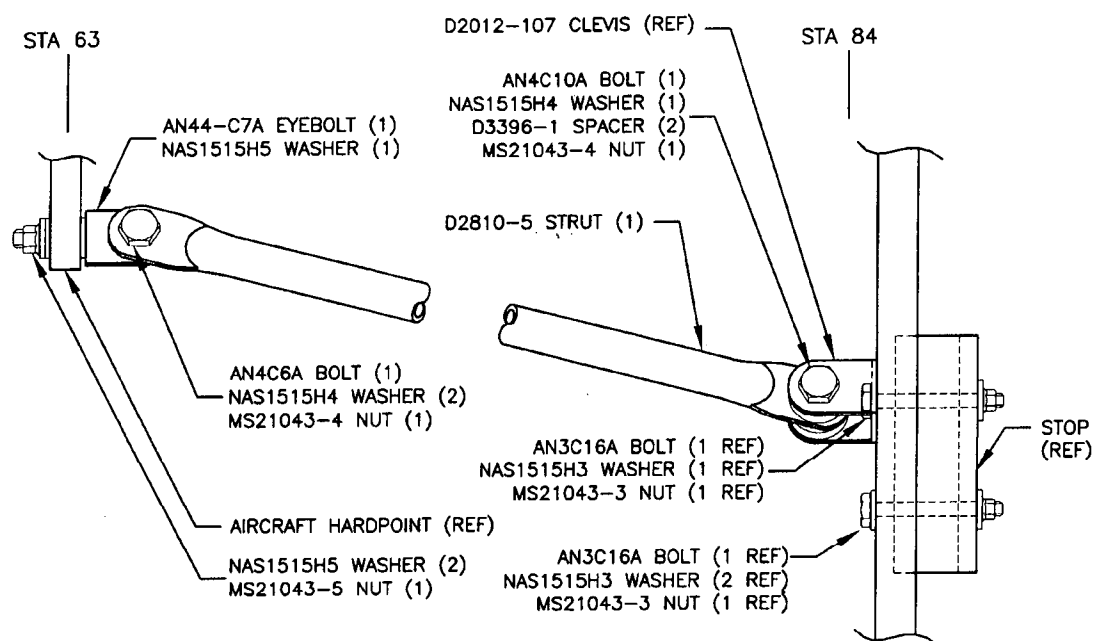
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

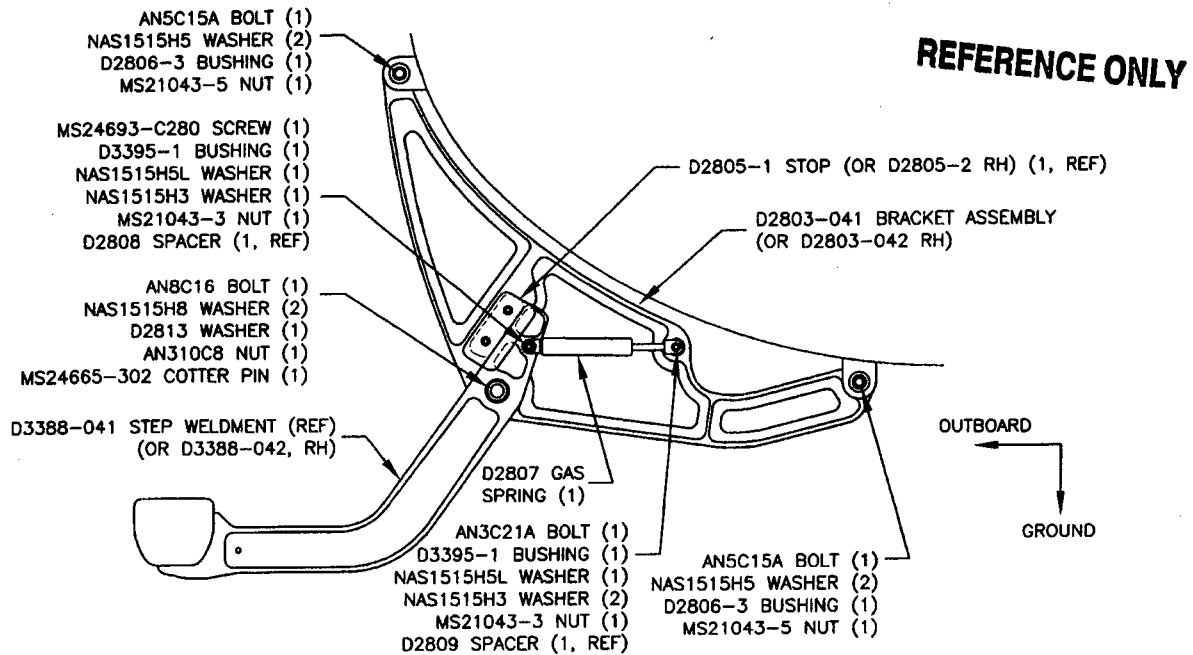
FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step*™ Installation
(NOT TO SCALE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25908

D412-630-023/-024 Heli-Access-Step™ Installation

**FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation
(View rotated 90° CW)**

